

Date: Wednesday, 29/10/2008 10:14:35 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE POSITIONER
Job Number	: 43064		
Estimate Number	: 13530		
P.O. Number	:	Part Number	: PB674300127
This Issue	: 29/10/2008 S.O. No. :	Drawing Number	: B6743001 P.4
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41295	Material	:
Written By	:	Due Date	: 05/11/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 08-11-04</u>		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product AN960JD10 → M105442 → Qty 3 QPL 08-11-27
MS27039104 BOLTS ARE TOO LONG NEED WASHER

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300135	PB67-43001-35 Lower Pad Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 PB67-43001-35 Lower Pad Assembly
 batch: 40064 41378

MF 08-11-04

2.0	PB674300131	PB67-43001-31 Upper Restraint Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 PB67-43001-31 Upper Restraint Weldment
 batch: 41377

MF 08-11-04

3.0	PB674300129	PB67-43001-29 Blade Positioner Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 PB67-43001-29 Blade Positioner Weldment
 batch: B43058

WIP MF 08-12-02

4.0	PB6743001285	PB67-43001-285 Upper Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 PB67-43001-285 Upper Tube
 batch: B40245

MF 08-11-04

5.0	PB674300119	PB67-43001-19 Inner Tube and Retainer Bu
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 PB67-43001-19 Inner Tube and Retainer Bu
 batch: B40240

MF 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/10/2008 10:14:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 43064

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Extension Tube Adjustmnt

batch: 41882

mf 08-11-04

7.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Adjustmnt Fitting

batch: 41375

mf 08-11-04

8.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clamp Bushing

40060

mf 08-11-04

9.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

batch: m18057

mf 08-11-04

10.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

batch: m18057

mf 08-11-04

11.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

batch: m108986

mf 08-11-04

12.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

batch: m108183

mf 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/10/2008 10:14:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 43064

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Screw

batch: M107378

UMF 08-11-04

14.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WASHER

batch: M109031

UMF 08-11-04

15.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Inventory

batch: M18431

UMF 08-11-04

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289 , -291 and -293 on -19 tube then slide it in -285 tube
2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg
3- assemble all parts as per dwg PB67-43001

FZ 08/12/02

①

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/02 (10)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPD 43067 8/12/04

185

54

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/04

Job Completion



UMF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

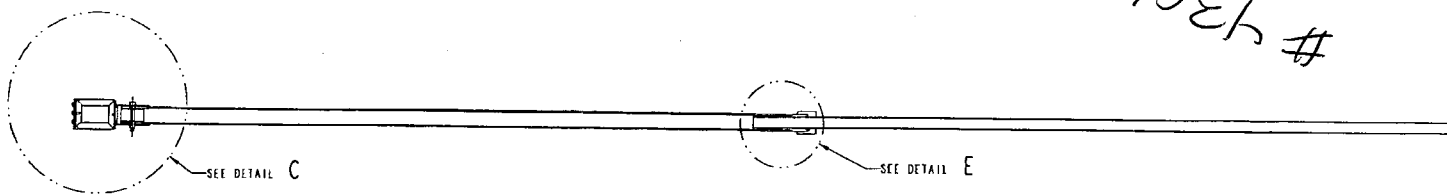
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

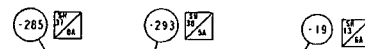
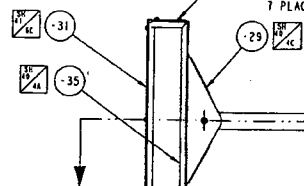
NOTE: Date & initial all entries

h908h #

RELEASED
4-16-72

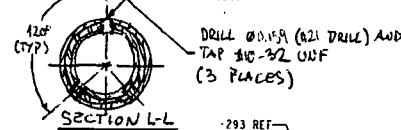


MS27038-1-09 SCREW
MS1149F0316P WASHER
Ø .193 THRU
WATCH DRILL -29 WITH NUTPLATE
LOC'S OF -35
7 PLACES

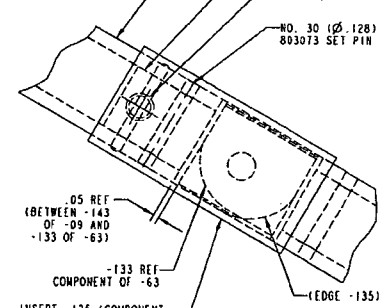


① -27 BLADE POSITIONER

FULLY EXTENDED THIS VIEW
SCALE 0.200



-243 REF (COMPONENT OF -09 ASSY)
-135 REF (COMPONENT OF -63)
DETENT COIL PIN



INSERT -135 (COMPONENT OF -63 ASSY) INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE 803073 SET PIN, ASSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.

DETAIL B
SCALE 2.000
(-09 ASSY)

PREMIER AVIATION, INC.
2800 Aviation Parkway, Grand Prairie, Texas 75050
D105UV8 B67-43001

ORIGINAL